

Work Order ID 66119

Monday, February 07, 2011 10:27:38 AM

Ship ASAP



PRELIMINARY ISSUE

Page 1

Item ID: D4268-047
Revision ID: PRELIM
Item Name: Instrument Panel Assembly (Optional)

Accept



Setup Start



Stop



Start Date: 2/7/2011 Start Qty: 1.00
Required Date: 2/7/2011 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D4268

PA1

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg (D4268-7)

Dwg Rev: PM

Prog Rev: PM

2-Deburr if necessary

B 11-2-7

(1)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B 11-2-7

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Required Date: 2/7/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date: QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00 - inspect to PA1

Don only

0.00 8/10/2011

QC

Memo

Quality Control

130

0.00

Small Fab

Memo

Small Fab

1- C'sink holes as per dwg
2- Deburr holes if necessary

0.00

135

Bend as per dwg

0.00

Brake NC

Memo

Brake NC

0.00

SPB 11/02/07

EPB 11/02/07

ⓧ

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Start Date: 2/7/2011 Start Qty: 1.00

Required Date: 2/7/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Run Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control



Cust Item ID:

Customer:



8/1/2012
inspector to PAI Day
only (41)

1 BR 1102-7

1 BR 1102-7

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Setup Start



Stop



Start Date: 2/7/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

0.00



Small Fab

Memo

0.00

Small Fab

Install nutplate as per dwg

GS 11/02/07 (1)

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*-inspected to PA1
Dwg only
8/10/07 (4)*

190

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

*Wyle
P.O.
11000327
30104109*

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Page 5

Item ID: D4268-047
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Item Name: Instrument Panel Assembly (Optional)

Accept



Setup Start



Stop



Start Date: 2/7/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

C.O.C only on Eagle
- PO-11-000327
- SO 104159.
email sent to Roberto 11:02:08
@ 10:45 AM.
2/11-02-08.

MF
11-02-07

POSITIVE RECALL
EFFECTIVE 11-02-07 AUTH
RELEASED DATE

Picklist Print

Monday, February 07, 2011 10:27:35 AM

Page 1

Work Order ID: 66119

Parent Item: D4268-047

Parent Item Name: Instrument Panel Assembly (Optional)

Start Date: 2/7/2011

Required Date: 2/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.02.07 new issue DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	194.2595	0.7447	0.783895			



2024-T3 .040 sheet

Location	Loc Qty	Loc Code
MAT	11.8	
114415	11.8	
MAT22	182.4595	
110305	21.93	
111786	9.66	
112291	22.45	
112331	52	
113162	76.4195	

-2 TOO SHORT

MS20426AD3 -3 Purchased No



Rivet

Location	Loc Qty	Loc Code
ST316	18375	
1173	8975	
13276	9400	

MS21059L3 Purchased No



Nut Plate

Location	Loc Qty	Loc Code
ST301	69	
114718	6	
116706	63	

11-2-7

①

111786

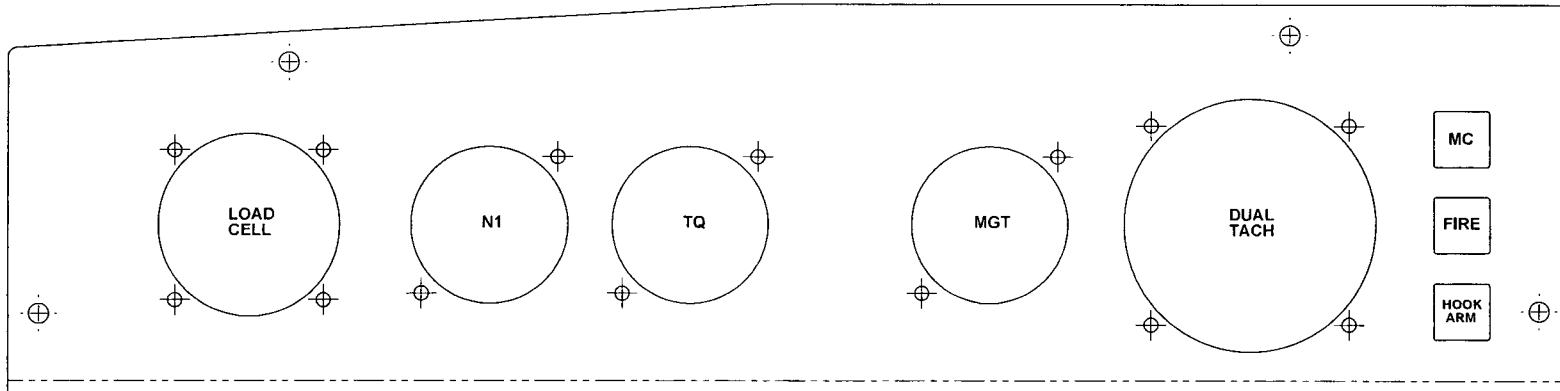
6 6
EJS 11/02/07

119099 @

3 3
EJS 11/02/07

3

C



5/2/87
-47

6/0 66119

DART AEROSPACE LTD		Work Order: 66119
Description: INSTRUMENT PANEL ASSEMBLY (OPTIONAL)		Part Number: D4268-047
Inspection Dwg: D4268-7, Rev: p11		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.102	X	V	V	13.02
Ø .191	+ .005 - .001	.195	X	V	V	
Ø .250	+ .005 - .001	.252	X	V	V	
Ø .177	+ .006 - .001	.180	X	V	V	
Ø 2.270	+ .012 - .001	2.276	X	V	V	
Ø 1.956	+ .012 - .001	1.955	X		V	
Ø 3.150	+ .012 - .001	3.154	X		V	
3.00	± .030	3.003	X		V	
2.50	± .030	2.507	X		V	
.849	± .010	.851	X		V	
.38	± .030	.383	X		V	
4.00	± .030	3.995	X		V	
.700	± .010	.704	X		V	
.375	± .010	.373	X		V	
5.50	± .030	5.502	X		V	
4.17	± .030	4.180	X		V	
1.68	± .030	1.683	X		V	
3.50	± .030	3.500	X		V	
.680	± .010	.687	X		V	
.344	± .010	.344	X		V	
6.00	± .030	6.003	X		V	
.35	± .030	.351	X		V	
12.50	± .030	12.50	X		V	7 13.01



Measured by: RB	Audited by: S	Prototype Approval:
Date: 11-2-7	Date: 11/2/07	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order:	66115
Description: Instrument Panel		Part Number:	D 4268-7
Inspection Dwg: D4268		Rev: PA1	Bent.
			Page 1 of 1

☒ First Article ☐ Prototype

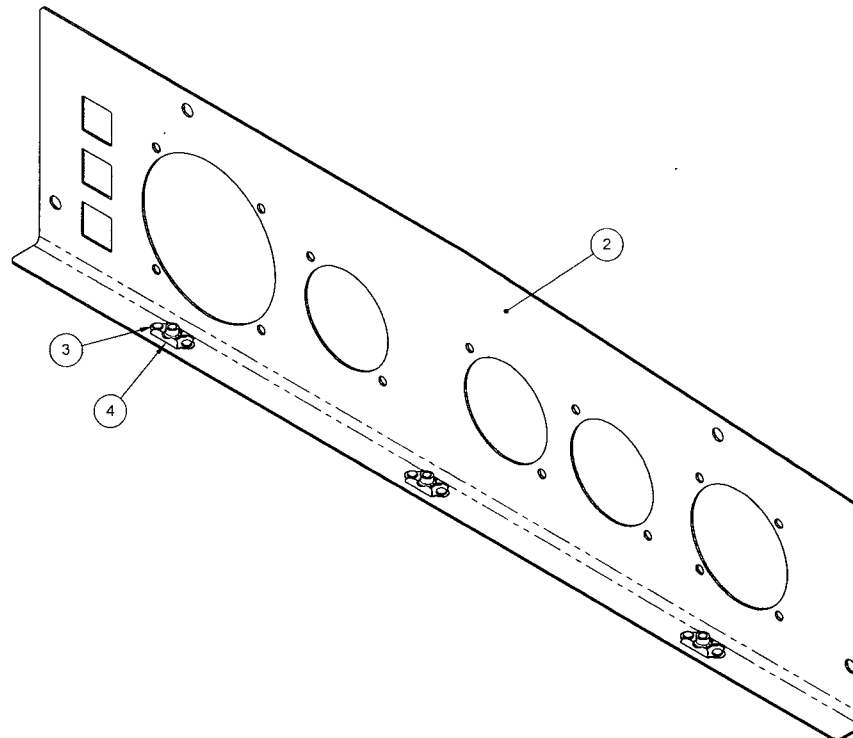
[illegible]

Measured by: 	Audited by: 	Prototype Approval:	N/A
Date: 4/02/08	Date: 4/02/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

ITEM	QTY -047	PART NUMBER	DESCRIPTION
1	X	D4268-047	INSTRUMENT PANEL, (OPTIONAL)
2	1	D4268-7	INSTRUMENT PANEL, (OPTIONAL)
3	6	MS20426AD3	RIVET
4	3	MS21059-3L	ANCHOR NUT

11.02.07 08102
-Z IS TOO SKRT.



11.02.07 08102

D4268-047 INSTRUMENT PANEL ASSEMBLY, (OPTIONAL)

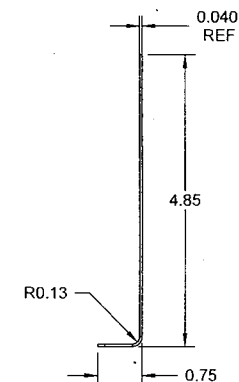
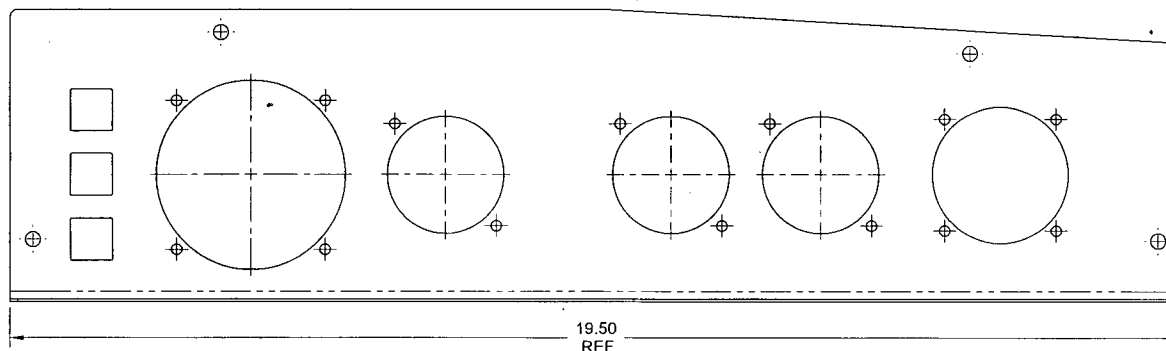
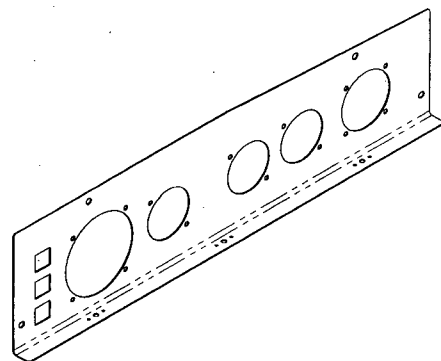
PRELIMINARY ISSUE

10.11.22

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.33 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. PA1
MFG. APPR.		D4268	SHEET 10 OF 12
APPROVED		TITLE	SCALE
DE APPR.		VRD PARTS	NTS
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D4268-7 INSTRUMENT PANEL, (OPTIONAL)

PRELIMINARY ISSUE

10.11.22

NOTES:

- 1) MATERIAL: MAKE FROM D4268-7F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 AND PRIME PER QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.33 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. PA1
MFG. APPR.		D4268	SHEET 11 OF 12
APPROVED		TITLE	SCALE
DE APPR.		VRD PARTS	NTS
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Jason Murdoch

From: Jason Murdoch <jmurdoch@dartaero.com>
Sent: Tuesday, February 08, 2011 10:44 AM
To: 'Fuentes, Roberto'
Cc: David Shepherd (dshepherd@dartaero.com)
Subject: D4268-047 Preliminary

Good morning Roberto,
How are you?

I am signing off a C.O.C for your preliminary D4268-047. Will the installation of this D4268-047 B66119 be determining the release of the drawing?

Jason Murdoch
Quality Coordinator
jmurdoch@dartaero.com
DART Aerospace Ltd.
613-632-5200

SO 104159

INV 104122